

Date: Wednesday, 10/31/2007 3:26:30 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOP PLATE
Job Number : 35488	
Estimate Number : 11211	
P.O. Number : N/A	Part Number : D33309
This Issue : 10/31/2007 S.O. No. : N/A	Drawing Number : D3330 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 34199	Material : N/A
Written By : _____	Due Date : 11/16/2007
Checked & Approved By : <u>10/31/07</u>	Qty: <u>15</u> Um: Each
Comment : Est: A 05.01.13 New issue KJ/JLM	
est B 07.05.14 rev C dwg EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0375X03500	1010-1025 Steel Bar
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S.1984



Comment: Qty.: 0.2888 f(s)/Unit Total : 2.8875 f(s)

1010-1025 Steel Bar

Fabricate Top Plate as per Dwg D3330

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 0.375" x 3.500" Ba

(M1010-B0.375x03.500)

Identify as D3330-9

Batch: M11223

DRMFS  
07-11-20  
07-11-20



2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07-11-21 (18)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS23

07-11-21 (18)

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07-11-22 (18)

Job Completion



07-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 01/12/22

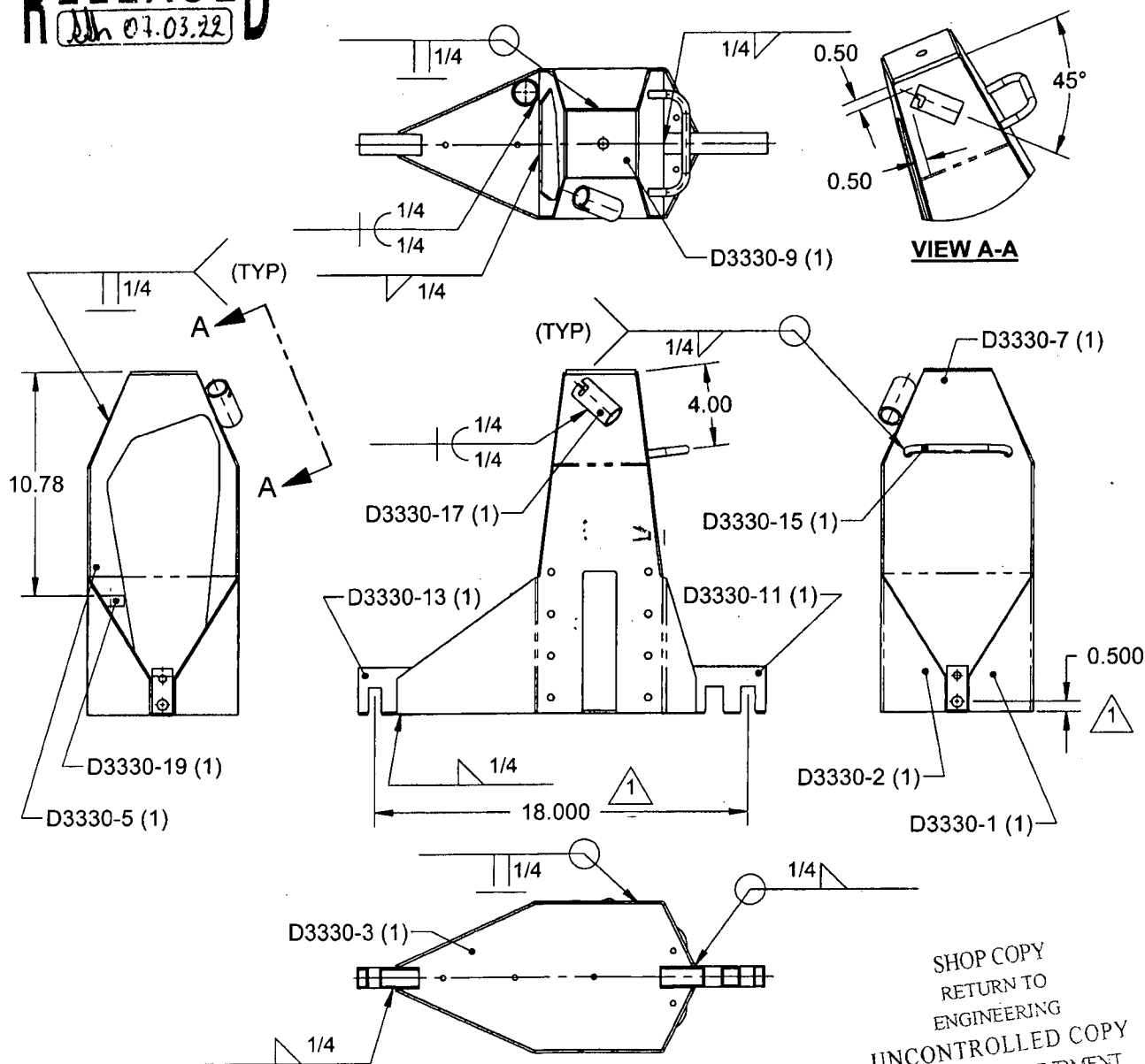
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
07.03.22

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CHECKED	APPROVED	DRAWING NO. <b>D3330</b>	REV. C SHEET 1 OF 9
DATE <b>07.03.20</b>	TITLE <b>FRAME WELDMENT</b>		SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

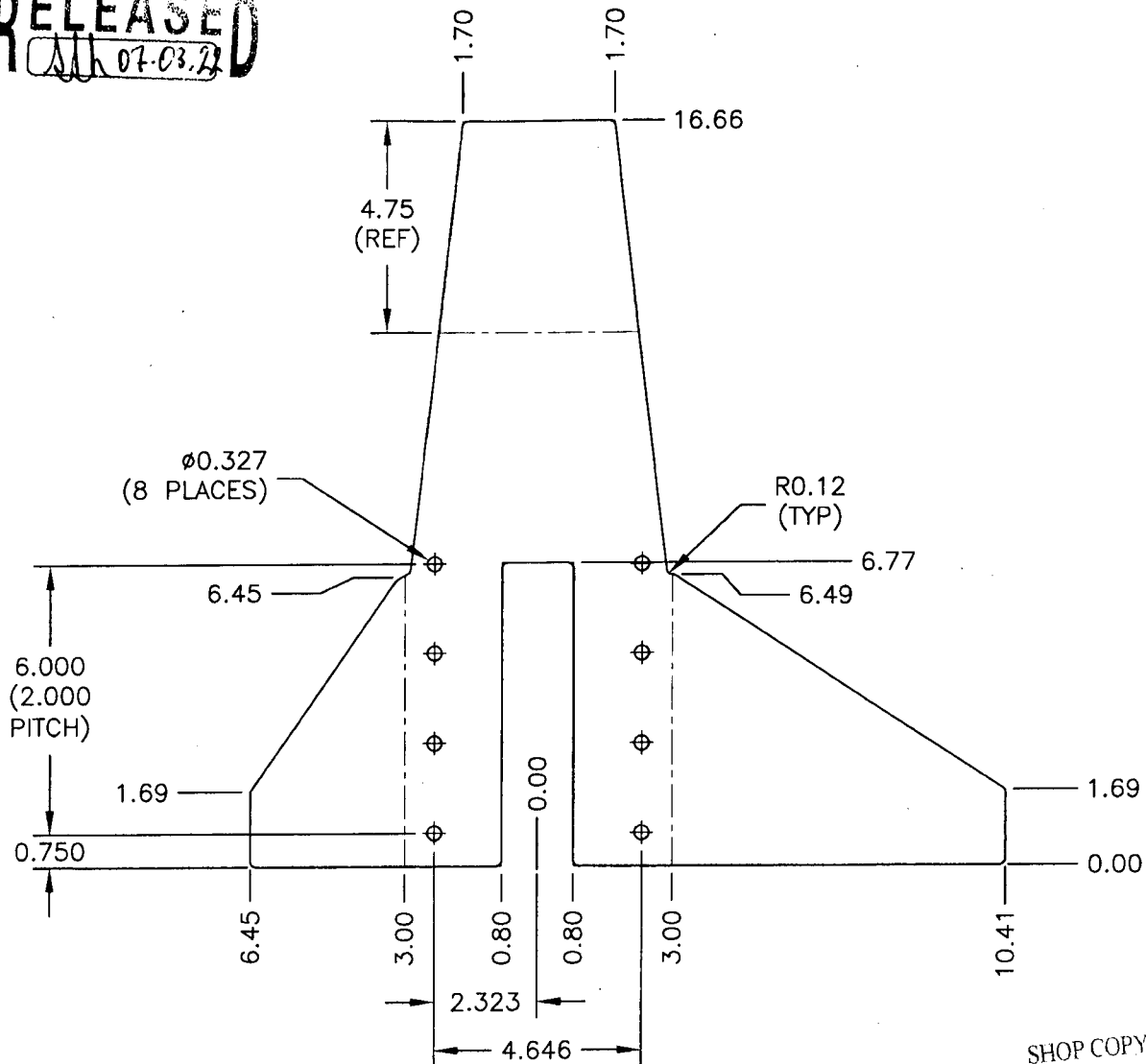
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

**RELEASED**  
*[Signature]* 07-03-20**D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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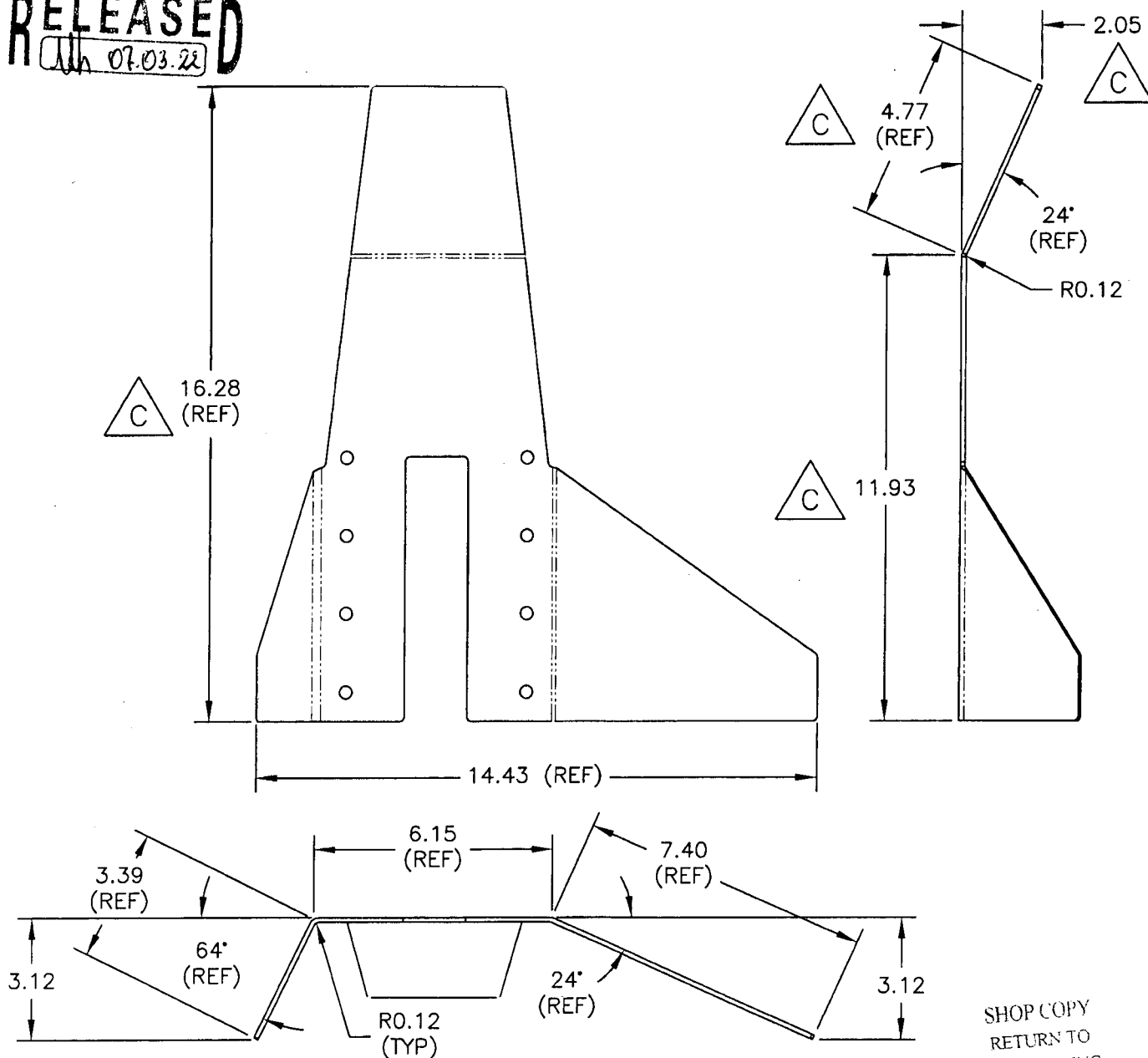
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**D3330-1 BEND DETAIL (SHOWN)**  
BEND D3330-2 (OPPOSITE)

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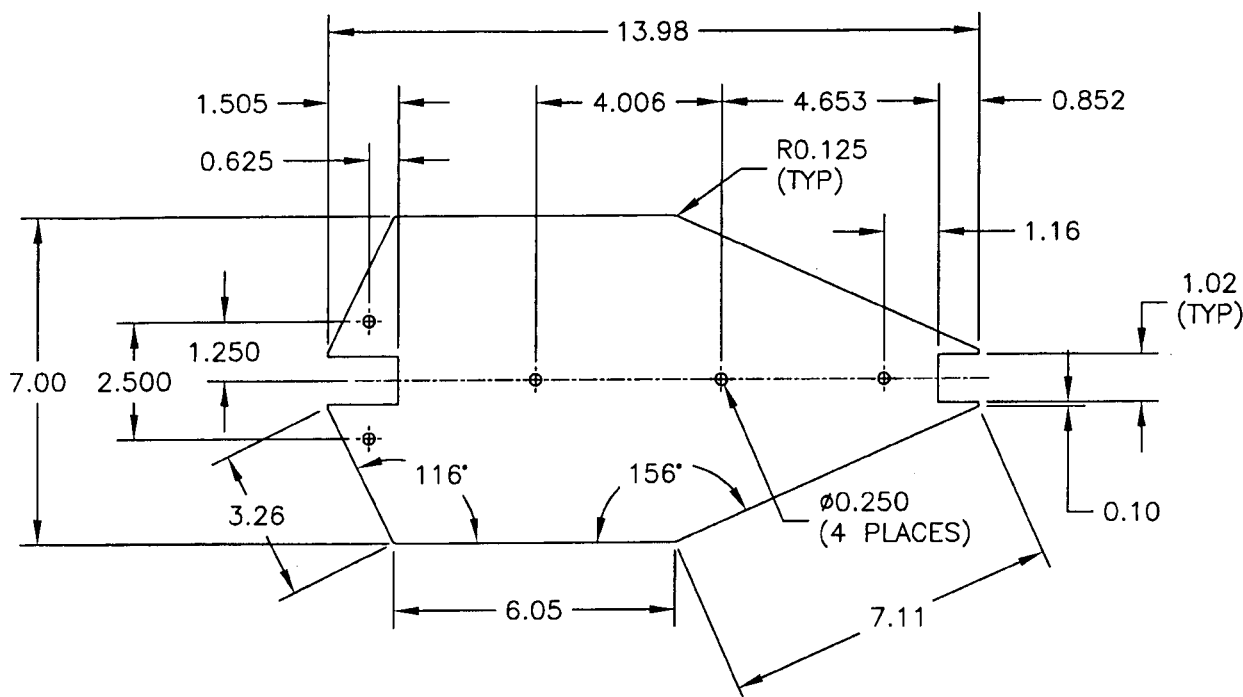
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07.03.20



### D3330-3 PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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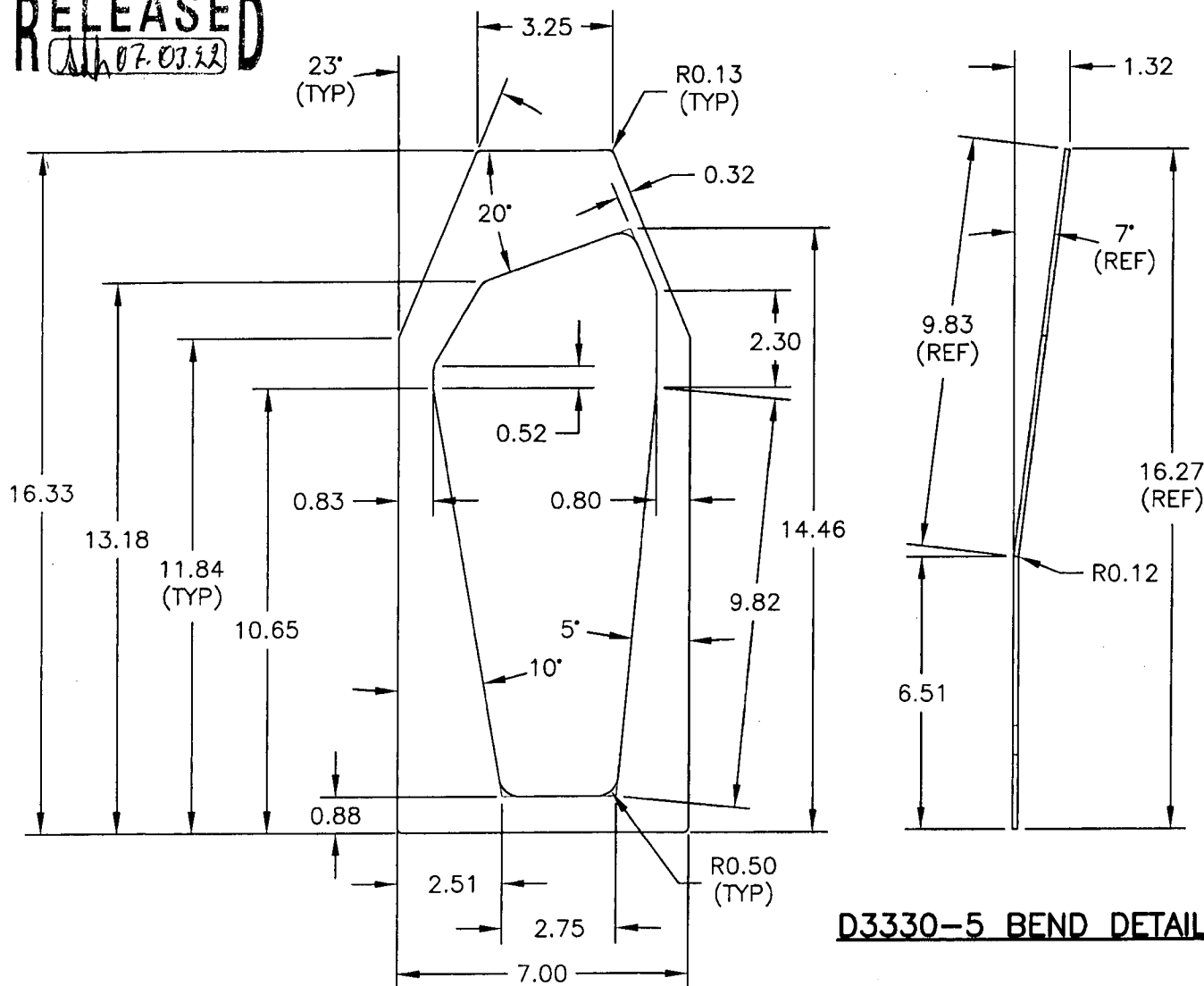
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**D3330-5 BEND DETAIL**

**FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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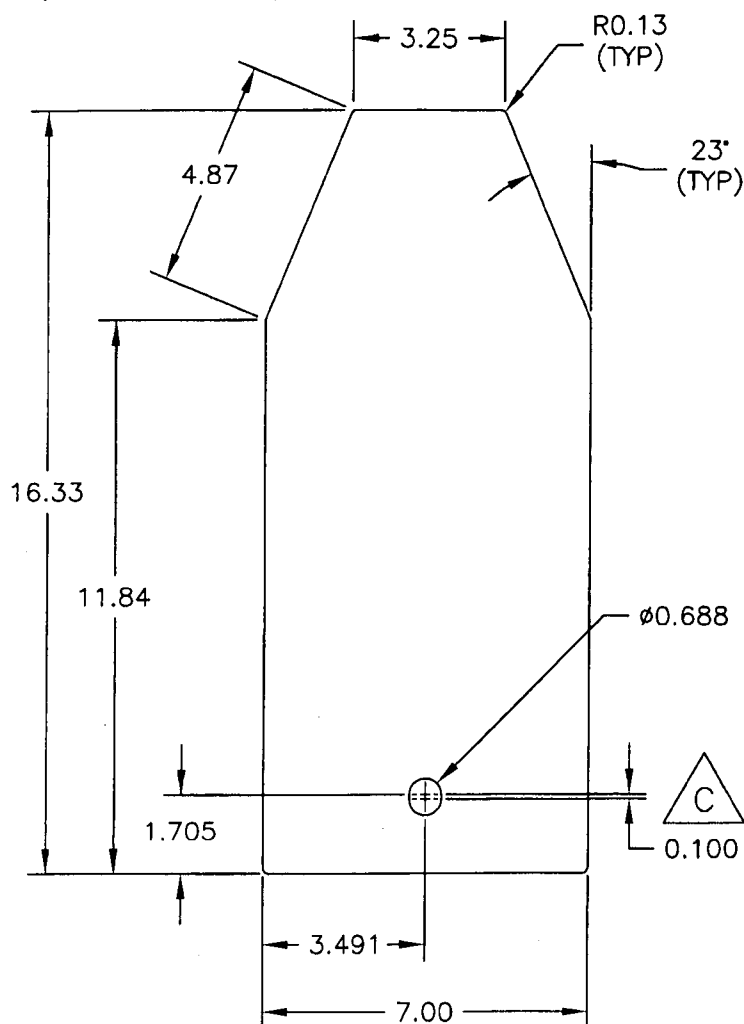
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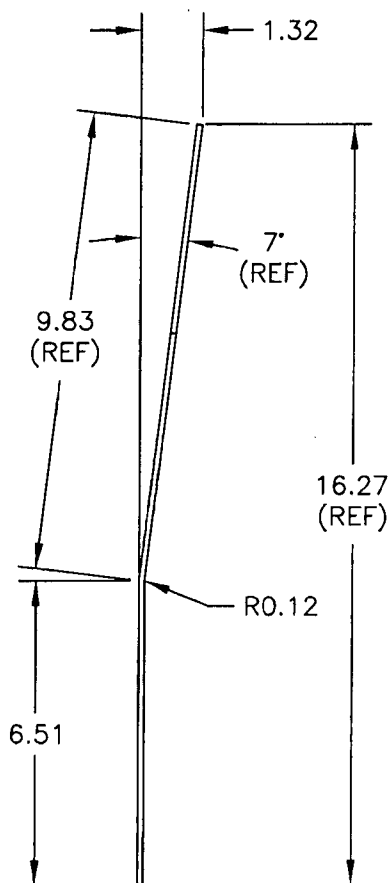


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FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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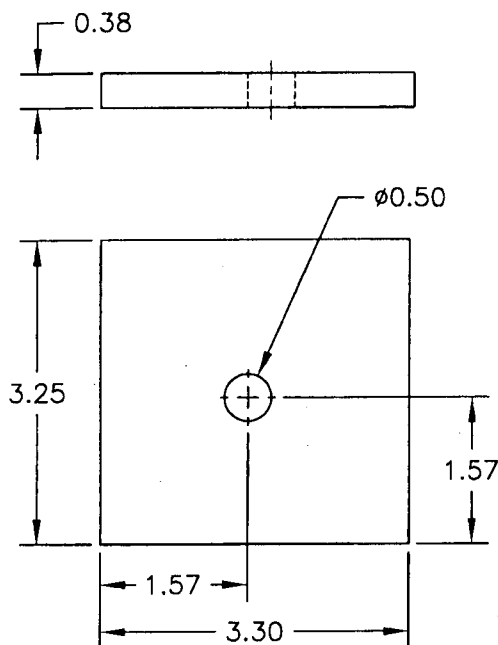
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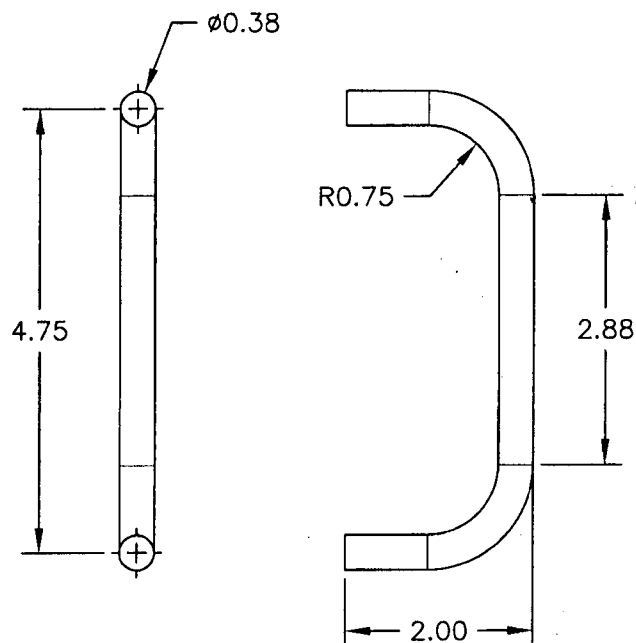


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1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL  
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

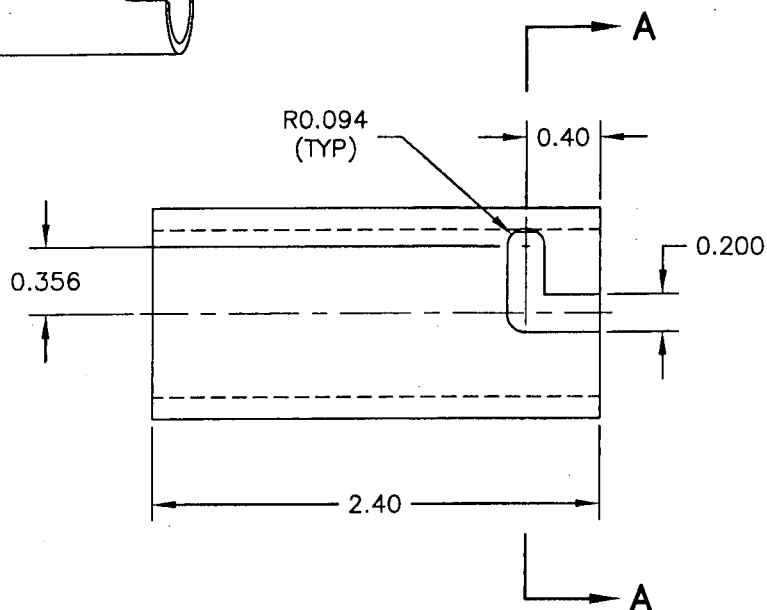
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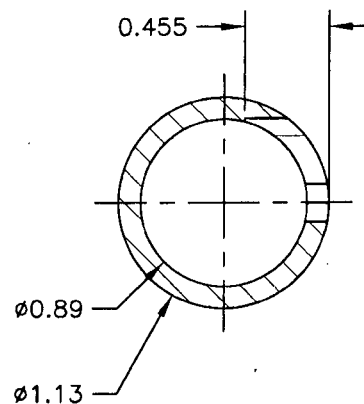
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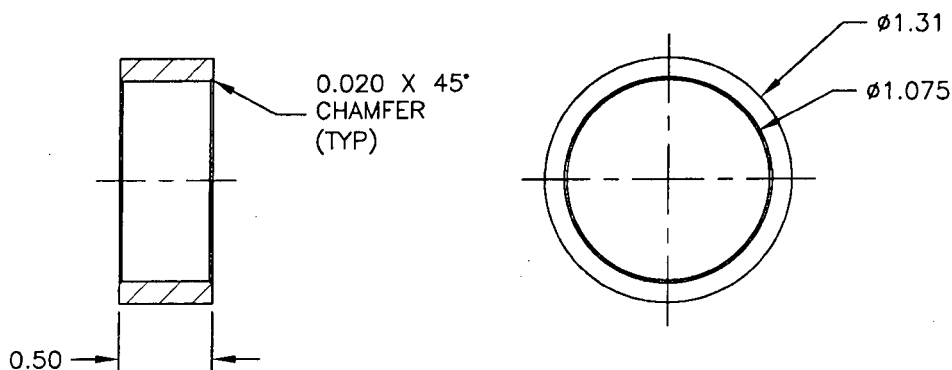


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SECTION A-A

### D3330-17 HANDLE SOCKET



### D3330-19 HANDLE RIM

#### NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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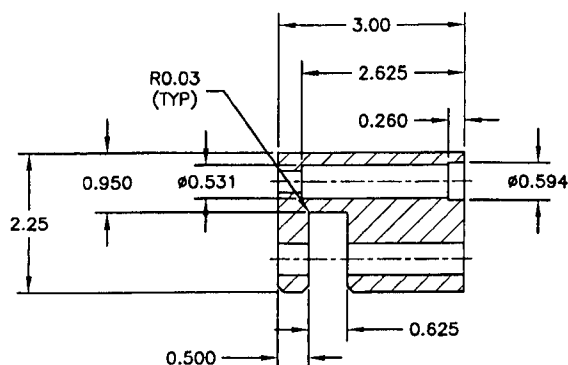
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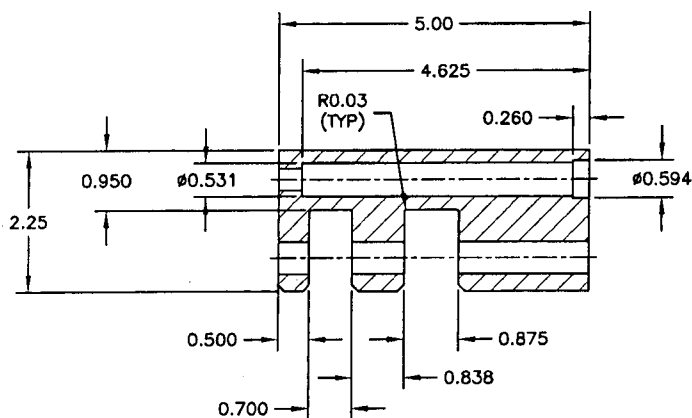
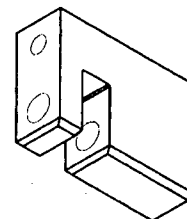
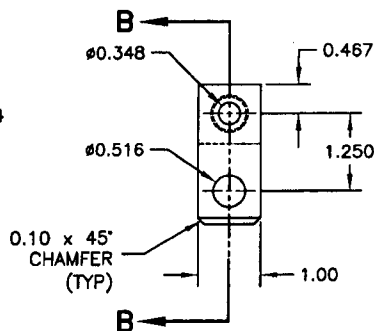
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:3

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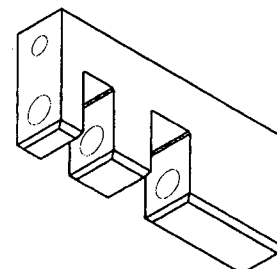
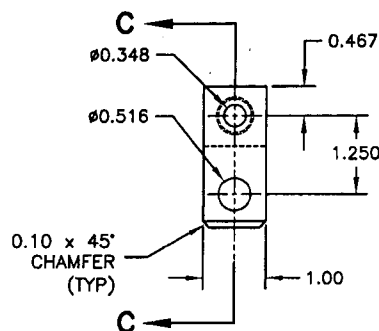
**SECTION B-B**

**D3330-13 SHORT PIN BRACKET**



**SECTION C-C**

**D3330-11 LONG PIN BRACKET**



**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x0.2.250)
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